

Date: Wednesday, 29/10/2008 10:10:59 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY		
Job Number	: 43061					
Estimate Number	: 13435					
P.O. Number	:		Part Number	:	PB674300111	
This Issue	: 29/10/2008	S.O. No. :	Drawing Number	:	B6743001 P.8	
Prsht Rev.	:	NC	Project Number	:	N/A	
First Issue	:	/ /	Drawing Revision	:	B1	
Previous Run	:	41365	Material	:		
Written By	:		Due Date	:	05/11/2008	Qty: 1 Um: Each
Checked & Approved By	:	MF 08-10-29				
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001247	Inner Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Inner Tube batch: B43072	
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Inner Tube Bushing batch: B4306941877	
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Gusset batch: 41492	
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Gusset batch: 41493	
5.0	PB674300167	PB67-43001-67	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		PB67-43001-67 batch: 41314	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
		Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg SP 08-11-20
7.0	QC9	VISUAL WELDING INSPECTION 
		Comment: VISUAL WELDING INSPECTION 10/08/11/21 (1)
8.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP S08/11/21 (1)
9.0	MS124780	HELICAL INSERT 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HELICAL INSERT B# 20117935 08-11-27 (1)
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- install helical insert as per dwg SAD 08-11-27 (1)
11.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP S08/11/27
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 n/n S 8/11/27
13.0	POWDER COATING	POWDER COATING 
		Comment: POWDER COATING M 102 316 (1X) 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 M-f 08/12/01

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: PB674300111

Job Number:



Seq. #: Machine Or Operation:

Description :

START TIME: 9-10

OVEN TEMPERATURE: 320° F

FINISH TIME: 9-40

(10)

m-1 08/12/01

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/12/01

15.0 PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

90 Degree Cover Plate

batch: 641511

FL

16.0 PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-83

batch: 641516

FL

17.0 MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: m109031

FL

18.0 NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m109031

FL

19.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(1)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

FL 08/12/01

W/O:		WORK ORDER CHANGES					
* DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



MF 08 12 01

(6)

Comment: INSPECT WORK TO CURRENT STEP

21.0 PACKAGING 1

PACKAGING RESOURCE #1



(P)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

FL 08/12/01

22.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/02 off

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-01

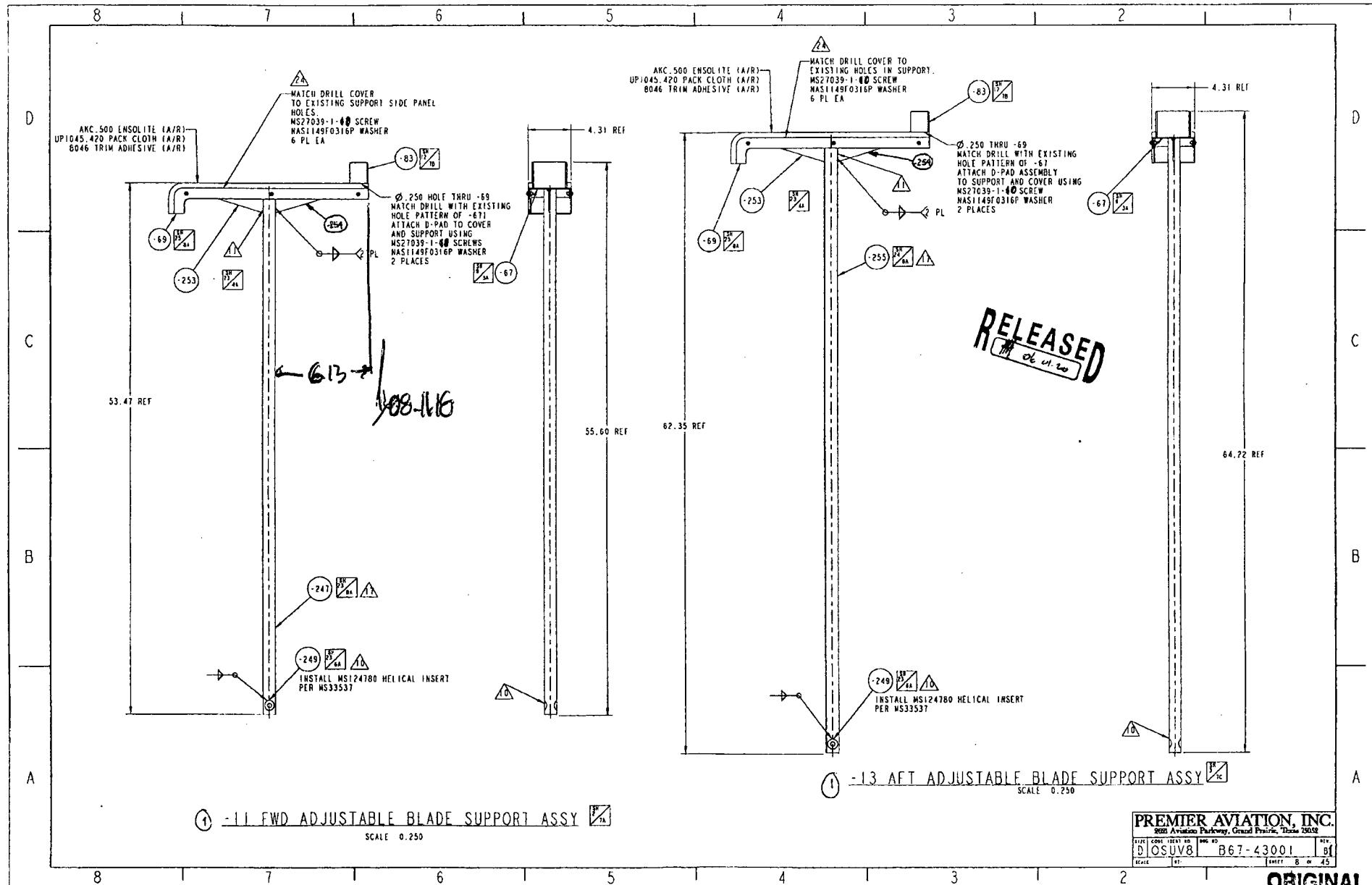
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# 4306/